

Fig.2(a)

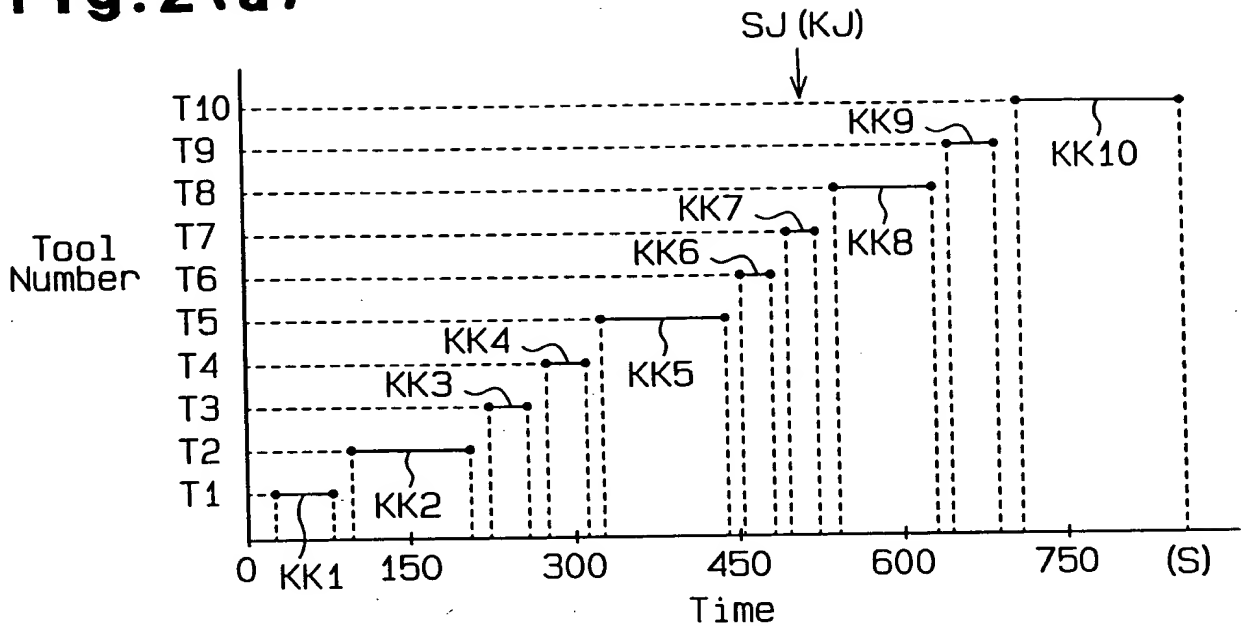


Fig.2(b)

STB

Ordinal Number (i)	1	2	3	4
Tool Number	T2	T5	T8	T10

Fig.2(c)

VTB

Tool Type	Drill	End Mill (Roughing)	Face Mill (Roughing)	End Mill (Finishing)	Face Mill (Finishing)
Sub-Routine Number	61	62	63	64	64

Fig.2(d)

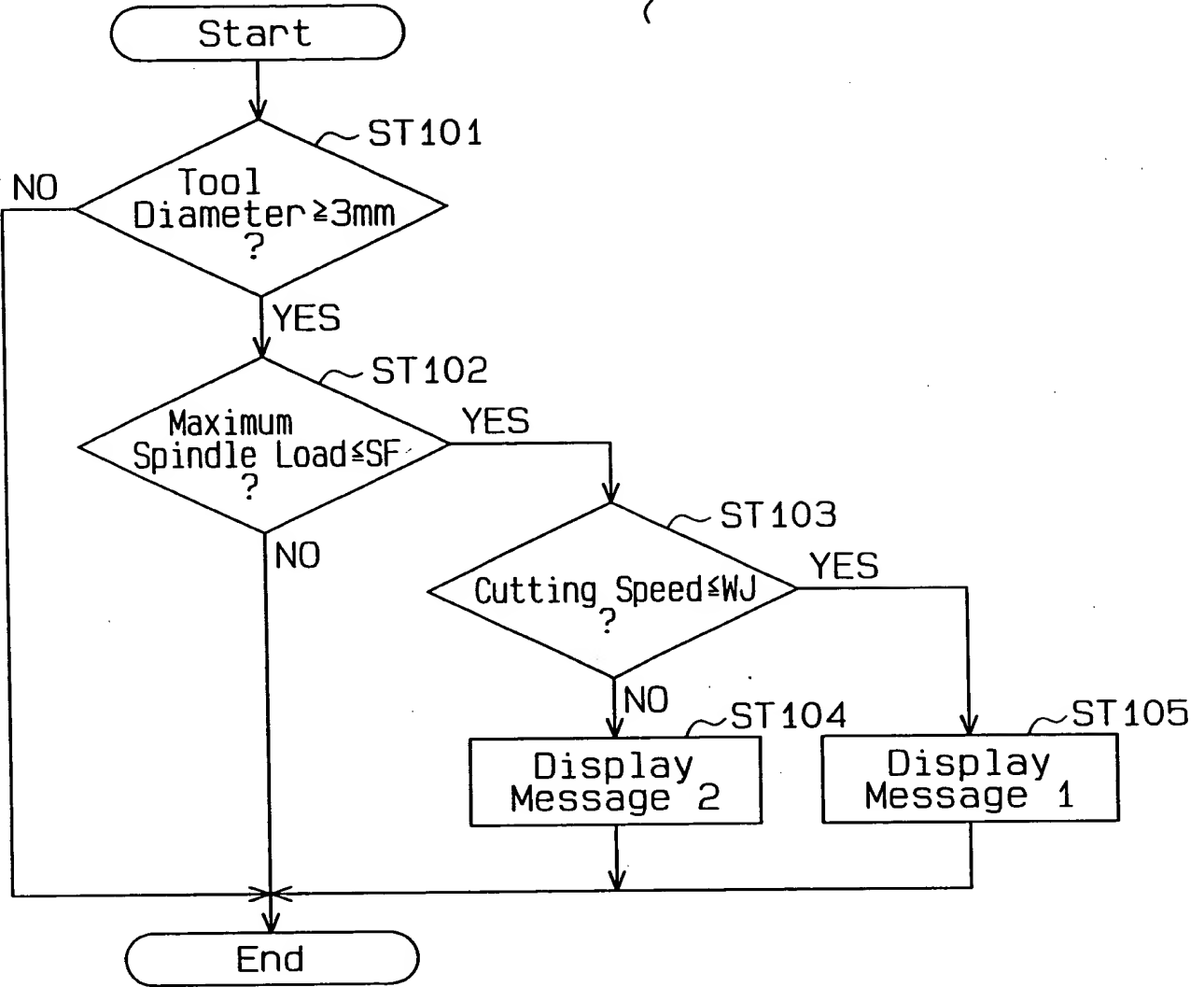
HJ (KJ)

Tool Number	T1	T2	T3	T4	T5	T6	T7	T8	T9	T10
Maximum Spindle Load (%)	72	60	54	57	81	73	45	67	39	58
Cutting Speed (m/min)	45.9	40.8	124.0	87.5	100.4	72.1	53.4	110.9	120.0	80.0
Rotating Speed (min ⁻¹)	185	163	496	350	401	288	213	662	480	320

Fig.4

SR61

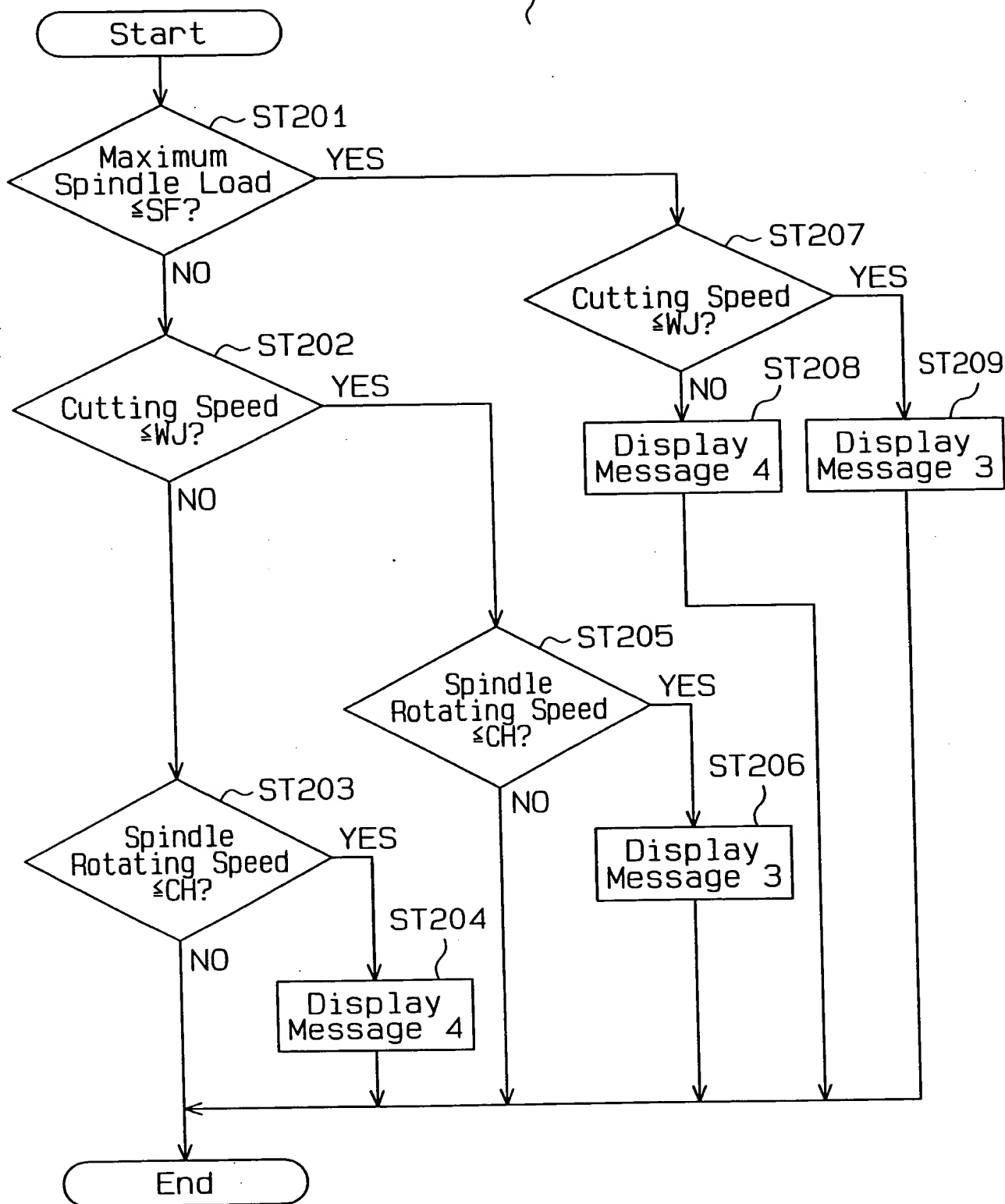
}



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Fig.5

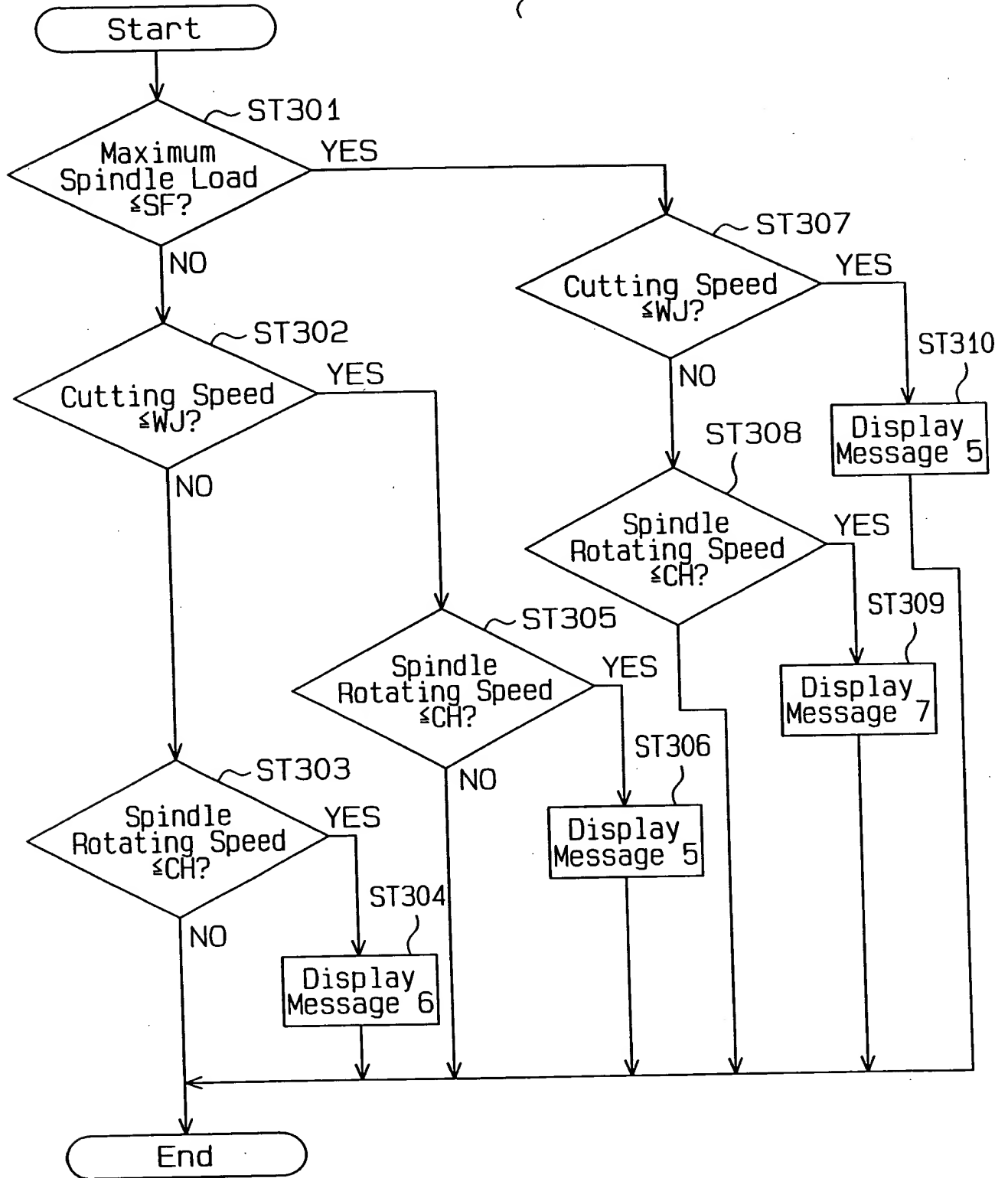
SR62



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Fig.6

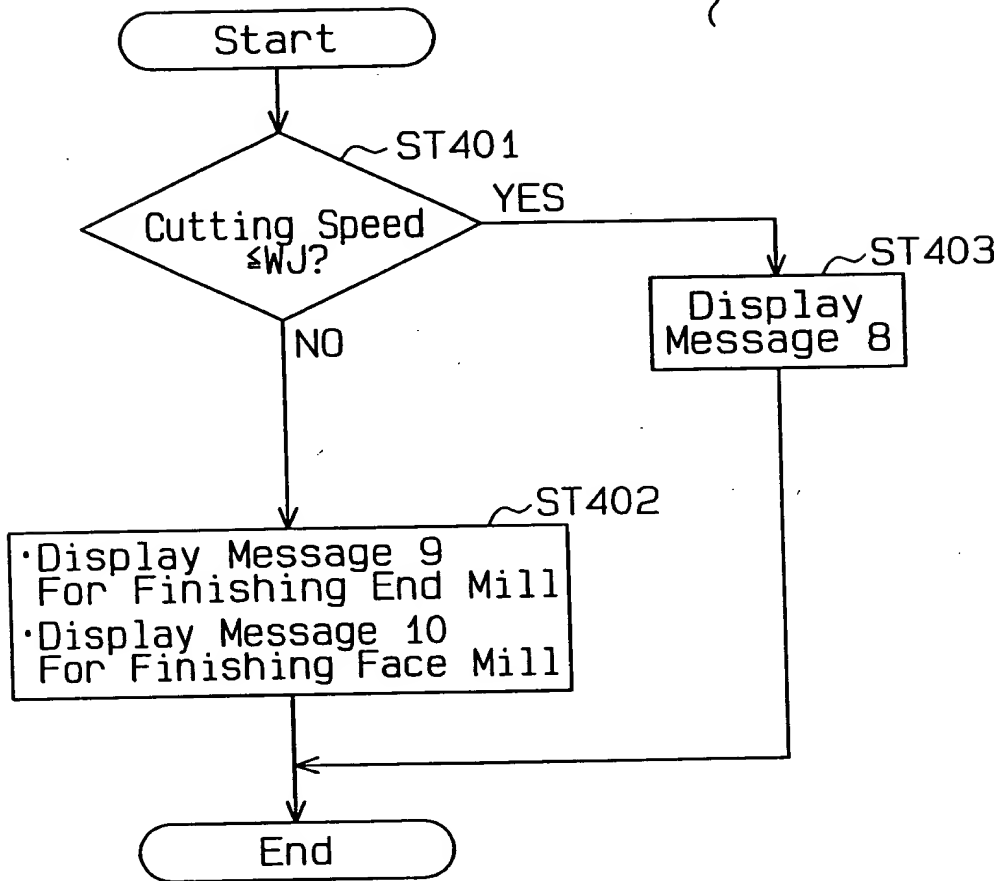
SR63



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Fig.7

SR64



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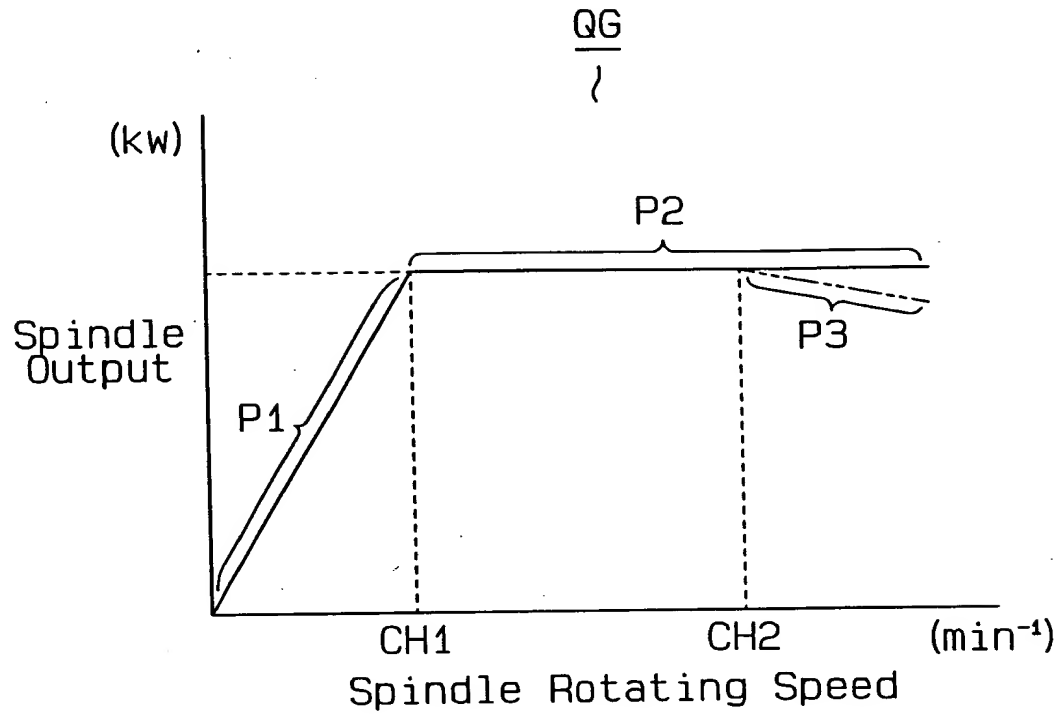
NJF

Fig. 8

Navigation Information Number	Message (MSG)
1	•Increase cutting speed to limit value
2	•Change cutting tool material and increase cutting speed Change HSS tool (small diameter) to carbide tool Change HSS tool (large diameter) to throw away tool Change carbide tool to coolant through tool (for spindle through machines) Change carbide tool to carbide coating tool (for non-spindle through machines)
3	•Increase cutting speed to limit value (fix cutting speed if cutting speed is equal to or higher than maximum spindle rotating speed)
4	•Change cutting tool material and increase cutting speed Change HSS tool (small diameter) to carbide tool Change HSS tool (large diameter) to throw away tool
5	•Increase cutting speed to limit value (fix cutting speed if cutting speed is equal to or higher than maximum spindle rotating speed)
6	•Change cutting tool material and increase cutting speed Change carbide tool to carbide coating tool (except when the workpiece material is AL)
7	•Decrease tool diameter and increase rotating speed
8	•Increase cutting speed to limit value (fix cutting speed if cutting speed is equal to or higher than maximum spindle rotating speed)
9	•Change to tool with a larger teeth number and increase feed rate •Change cutting tool material and increase cutting speed Change HSS tool to carbide tool Change carbide tool to carbide coating tool (except when the workpiece material is AL)
10	•Change to tool with a larger teeth number and increase feed rate •Change cutting tool material and increase cutting speed (except when workpiece material is AL) Change carbide tool to carbide coating tool or cermet tool Change carbide coating tool to cermet tool

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Fig.12



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